

STEEL RULE PRODUCTS



CUTTING RULES

ECONO•CORR

CREASING RULES

SPECIAL RULES

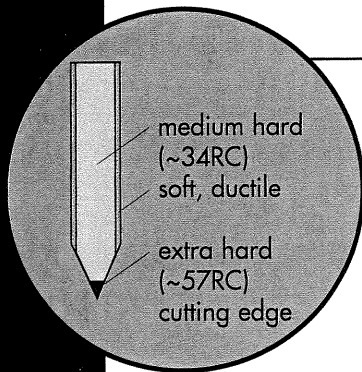
ROTARY RULES



BÖHLER

BÖHLER CUTTING RULES

All Böhler Rules are laser accurate achieved through great precision of shape and dimensions.



BÖHLER CUTTING RULE UNIVERSAL

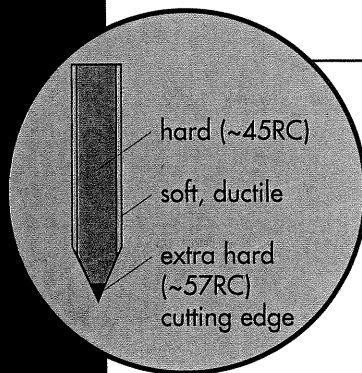
Benefits:

- Medium hard body and a soft, ductile outer skin.
- A perfectly shaved bevel, standard or a precision ground edge on request.
- Extra hard cutting edge.
- Excellent bendability.
- Uniform straightness.
- Uniform height and width.

Applications:

Cardboard
Corrugated board
Labels
Postcards
Business cards
Jigsaw puzzles

The BÖHLER UNIVERSAL rule has the excellent bending properties of a soft steel, with the long service life of an extra hard cutting edge and can be universally used.



BÖHLER CUTTING RULE UNIVERSAL 60

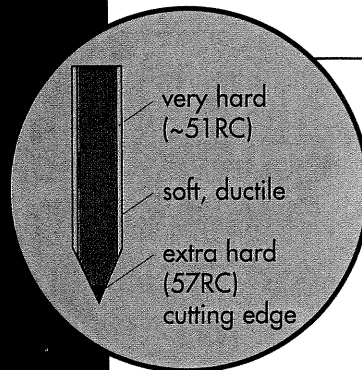
Benefits:

- Hard body and a soft, ductile outer skin.
- A perfectly shaved bevel, standard or a precision ground edge on request.
- Extra hard cutting edge.
- Good bendability.
- Uniform straightness.
- Uniform height and width.

Applications:

Plastics
Synthetics
Thin gaskets
Foil
Jigsaw puzzles

UNIVERSAL 60 ... this rule combines the body hardness level of the TOP rule with the advantages of an induction hardened cutting edge. This gives high rigidity, outstanding wear resistance and longer service life.



BÖHLER CUTTING RULE UNIVERSAL 75

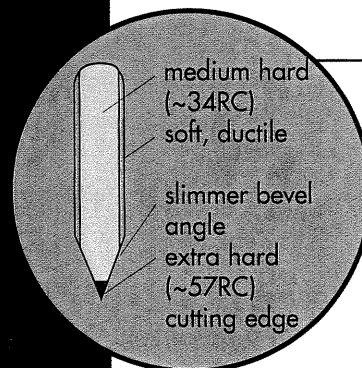
Benefits:

- Very hard body and a soft, ductile outer skin.
- A perfectly shaved bevel, standard or a precision ground edge on request.
- Extra hard cutting edge.
- Reliable 90° bendability.
- Uniform straightness.
- Uniform height and width.

Applications:

Non-asbestos gaskets
Glass fiber laminates
Carbon fiber plates
Metal foils
Floor coverings
Plastics and synthetics

UNIVERSAL 75 ... this rule has excellent stability as well as wear resistance. It is very well suited to cutting heavy materials such as non-asbestos gaskets and other abrasive materials.



BÖHLER CUTTING RULE UNIVERSAL SUPER

Benefits:

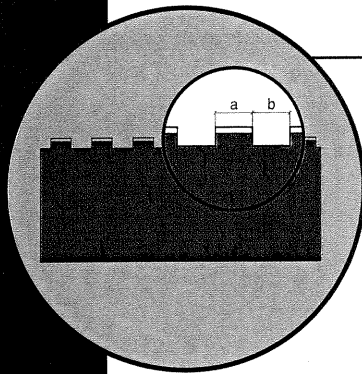
- Medium hard body and a soft, ductile outer skin.
- A slimmer cutting bevel, 45°.
- Extra hard cutting edge.
- Excellent bendability.
- Uniform straightness.
- Uniform height and width.
- Exclusive "K-back"

Applications:

Cardboard
Corrugated board
Recycled stock

BÖHLER SPECIAL RULES

All Böhler Rules are laser accurate achieved through great precision of shape and dimensions.



BÖHLER PERFORATING RULES TOP

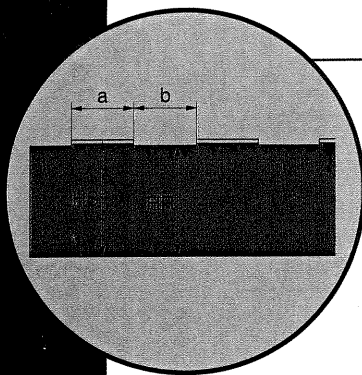
Böhler perforating rules are available in a wide range of various thicknesses and tooth/gap combinations.

The spacing is usually given in mm.

On request, we can also manufacture in point and inch spacings.

Please Specify:

a = width of tooth
b = width of gap



BÖHLER CUT-CREASE RULES TOP

This rule spares the user the unpleasant task of alternately inserting individual cutting and creasing rules.

The length of the cut and crease, as well as the height of the cutting and creasing part are to be specified.

Please Specify:

a = width of tooth
b = width of gap
HS = height of cutting part
HR = height of creasing part



BÖHLER GLUE FLAP RULES TOP

Glue flap rules are wave edge perforating rules which are manufactured in the same heights as scoring rules.

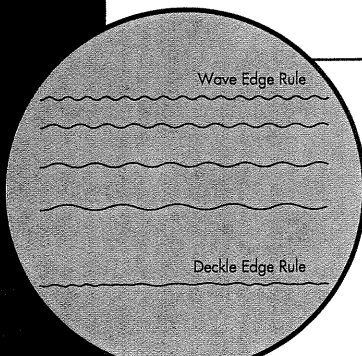
They are used to roughen the glue flaps on cardboard boxes to obtain a firm grip surface for the adhesive.

Tooth/Gap:

2pt / 2pt

Wave Spacing W:

5 mm (0.197")



BÖHLER WAVE EDGE RULES TOP, UNI

The main area of application for wave edge rules is in the production of safety cutting edges on cardboard and corrugated board, to avoid hand injuries during manual erection of the box sections. Deckle edge rules are used to cut postcards, greeting cards and business cards.

Wave Spacing W:

3.5 mm - very fine
5.0 mm - fine
7.0 mm - medium
10.0 mm - large

SHAVED (DRAWN) CUTTING EDGE

The standard condition of Böhler cutting rules is a precision drawn, high surface quality cutting edge.

The cutting rule has a smooth surface with a sharp cutting edge, which minimizes the formation of dust during application and ensures an easy penetration into the material being cut.

Also available in ground edge condition.

Used for:

Böhler TOP
Böhler H 75
All Universal-type cutting rules
Böhler special rules

CUTTING BEVELS

CF - Center Face (Double Bevel)

This is the most commonly used cutting edge for all standard cardboard. Approximately 80 - 85% of all cutting rules used have this bevel.

SF - Side Face (Single Bevel)

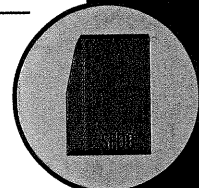
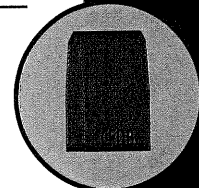
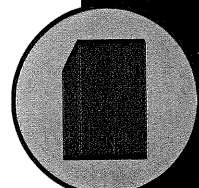
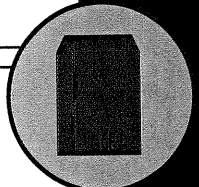
This type of cutting edge is particularly suitable for cutting gaskets, displays and close shapes. The minimum counter bevel facilitates a right-angled, straight cut.

CFDB - Center Face Double Bevel (Double Long Bevel)

This type of cutting edge reduces the cutting power required when cutting hard and/or thick materials, such as glass fiber reinforced laminates, leather, cork, rubber, jigsaw puzzles, corrugated board, plastics, plywood, etc.

SFDB - Side Face Double Bevel (Long Single Bevel)

The SFDB profile offers the same advantages as the CFDB when cutting thicker material. SFDB has the added advantage that the material being cut is left with a square 90° cut edge and all the distortion from penetration is left on the material waste.



BÖHLER CREASING RULES

The design of boxes is becoming ever more complex and due to the continually increasing speed of packaging production machinery, the use of high quality creasing rules is becoming increasingly important.

- Very smooth crease head surface.
- A perfectly radiused, smooth profile.
- A flowing continuity from the radiused profile to the side faces of the rule.
- Minimum eccentricity.
- Minimum height tolerances.
- Rule thickness complementary to cutting rules.
- SUPREME - coating possible.

Böhler Creasing Rules available in a wide variety of sizes.

As per the size

Single
Round



Double
Round



Wide Top

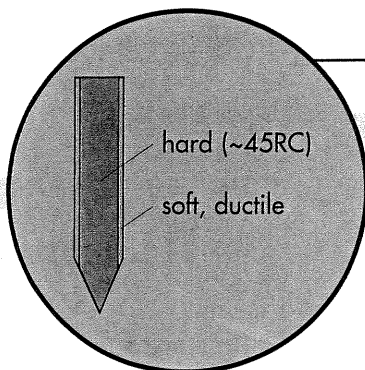


Narrow
Top



BÖHLER CUTTING RULES

All Böhler Rules are laser accurate achieved through great precision of shape and dimensions.



BÖHLER CUTTING RULE TOP

Benefits:

- Uniform hard body and a soft, ductile outer skin.
- A perfectly shaved bevel.
- Good bendability.
- Uniform straightness.
- Uniform height and width.
- Also used for Böhler special rules.

Applications:

Cardboard
Corrugated board
Labels
Postcards
Business cards

TOP ... this all purpose rule from Böhler offers excellent bendability with a good hardness ratio and is suitable for slightly abrasive materials. Used in place of a wide variety of conventional cutting rules.

BÖHLER ECONO•CORR

Benefits:

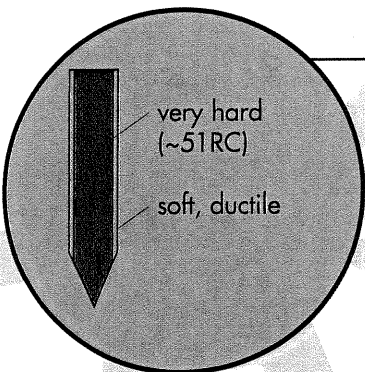
- Sold in 3pt x .937 30" lengths
- Now available in coils, regular and reverse wound.

Applications:

Cardboard
Corrugated board

econo•CORR

Econo•Corr...the very best quality utility rule created at a penny-wise price.



BÖHLER CUTTING RULE H 75

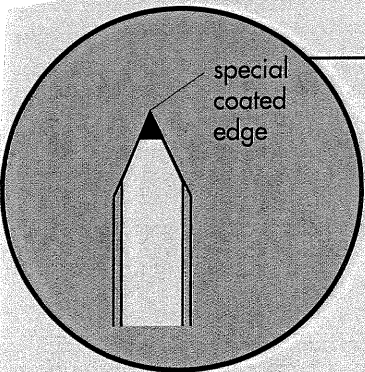
Benefits:

- Very hard body and a soft, ductile outer skin.
- A perfectly shaved bevel.
- Highest stability and 90° bendability.
- Uniform straightness.
- Uniform height and width.

Applications:

Gaskets
Rubber
Plywood
Cork
Felt
Beer mats

H 75 ... a very hard rule, which after controlled surface decarburization can be bent 90° and offers the highest stability and performance during difficult cutting operations.



BÖHLER CUTTING RULE SUPREME

Benefits:

- Special edge coating for smoothness and dust-reduced cutting.
- Particularly suitable for recycled cardboard.
- Reduction in cutting force required.
- Reduction in friction between the cutting edge and the material being cut.
- Substantially increased service life of the die.

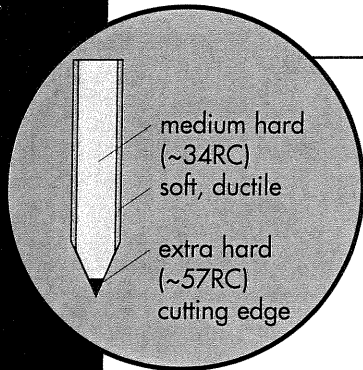
Applications:

For long run applications like solid carton packaging in the food, pharmaceutical and cigarette industries.

SUPREME ... by means of a special process the cutting edge of the Supreme rule is coated with a thin anti-friction-film which fills the microscopic pores and marks on the cutting edge and adds to the smoothness and reduces the friction.

BÖHLER CUTTING RULES

All Böhler Rules are laser accurate achieved through great precision of shape and dimensions.



BÖHLER CUTTING RULE UNIVERSAL

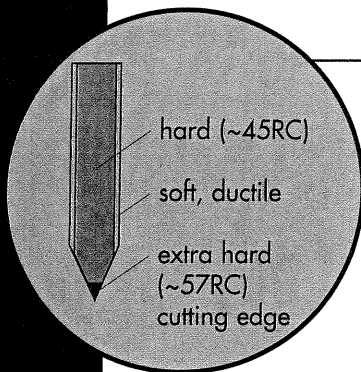
Benefits:

- Medium hard body and a soft, ductile outer skin.
- A perfectly shaved bevel, standard or a precision ground edge on request.
- Extra hard cutting edge.
- Excellent bendability.
- Uniform straightness.
- Uniform height and width.

Applications:

Cardboard
Corrugated board
Labels
Postcards
Business cards
Jigsaw puzzles

The BÖHLER UNIVERSAL rule has the excellent bending properties of a soft steel, with the long service life of an extra hard cutting edge and can be universally used.



BÖHLER CUTTING RULE UNIVERSAL 60

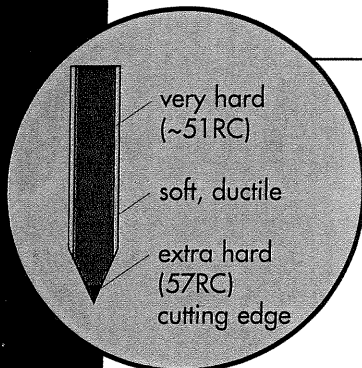
Benefits:

- Hard body and a soft, ductile outer skin.
- A perfectly shaved bevel, standard or a precision ground edge on request.
- Extra hard cutting edge.
- Good bendability.
- Uniform straightness.
- Uniform height and width.

Applications:

Plastics
Synthetics
Thin gaskets
Foil
Jigsaw puzzles

UNIVERSAL 60 ... this rule combines the body hardness level of the TOP rule with the advantages of an induction hardened cutting edge. This gives high rigidity, outstanding wear resistance and longer service life.



BÖHLER CUTTING RULE UNIVERSAL 75

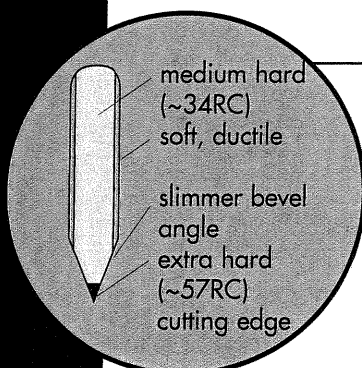
Benefits:

- Very hard body and a soft, ductile outer skin.
- A perfectly shaved bevel, standard or a precision ground edge on request.
- Extra hard cutting edge.
- Reliable 90° bendability.
- Uniform straightness.
- Uniform height and width.

Applications:

Non-asbestos gaskets
Glass fiber laminates
Carbon fiber plates
Metal foil
Floor coverings
Plastics and synthetics

UNIVERSAL 75 ... this rule has excellent stability as well as wear resistance. It is very well suited to cutting heavy materials such as non-asbestos gaskets and other abrasive materials.



BÖHLER CUTTING RULE UNIVERSAL SUPER

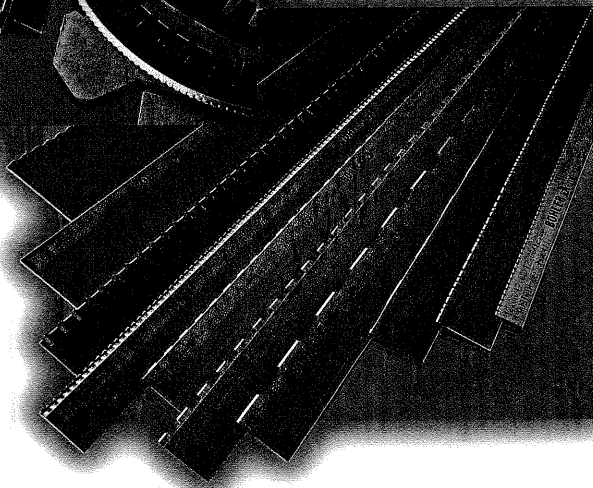
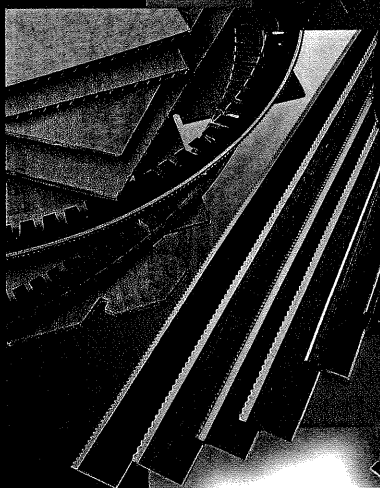
Benefits:

- Medium hard body and a soft, ductile outer skin.
- A slimmer cutting bevel, 45°.
- Extra hard cutting edge.
- Excellent bendability.
- Uniform straightness.
- Uniform height and width.
- Exclusive "K-back"

Applications:

Cardboard
Corrugated board
Recycled stock

STEEL RULE PRODUCTS



CUTTING RULES

ECONO•CORR

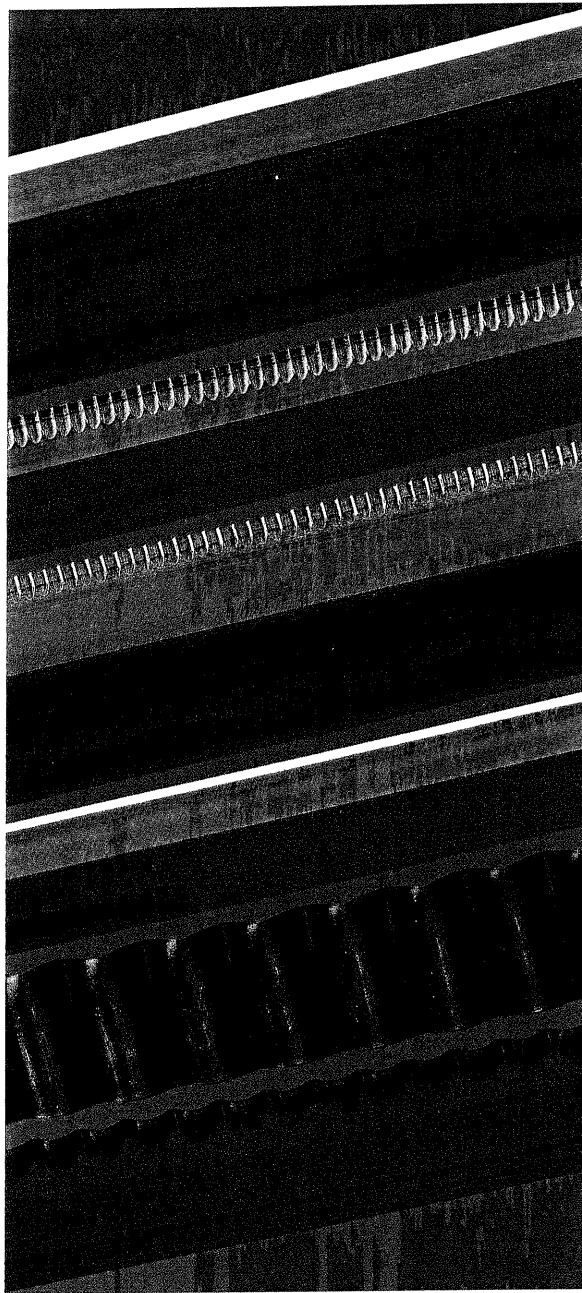
CREASING RULES

SPECIAL RULES

ROTARY RULES



 **BÖHLER**



Stanzmesserstahl

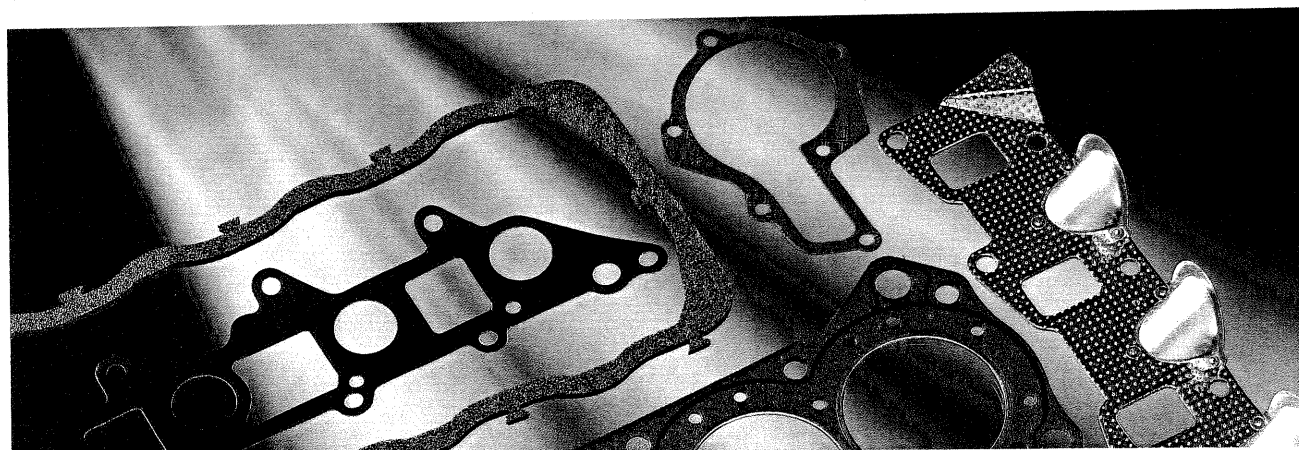
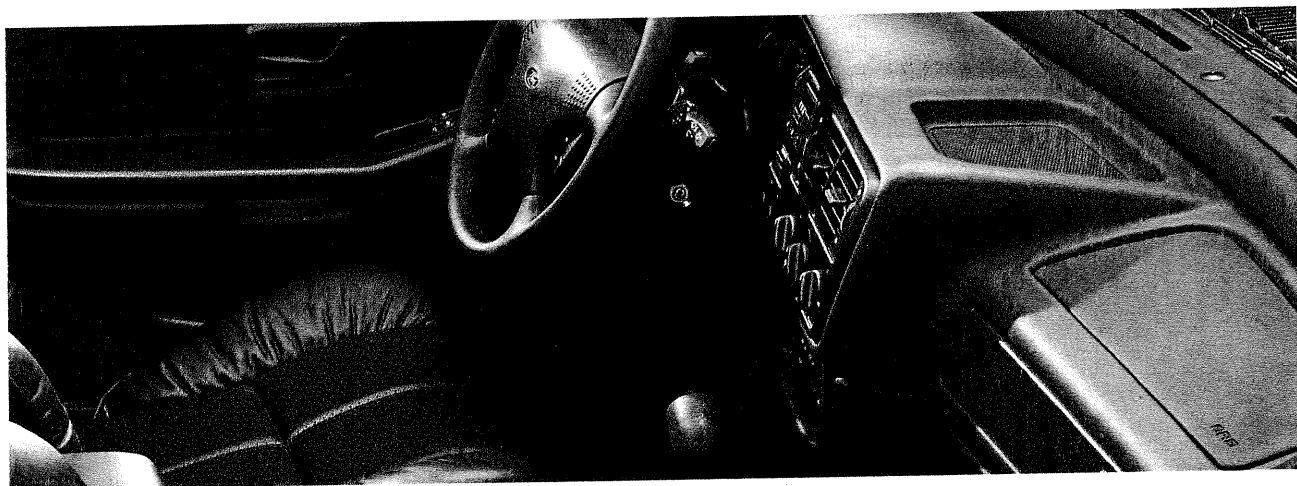
Clicking die steel

*Feuillard pour
emporte-pièces*

*Fleje de acero para
troqueles*




 VIKING®

 **VIKING**
MARTIN MILLER





INHALTSVERZEICHNIS – CONTENTS – CONTENU – CONTENIDO

 VIKING FLEX GOLD	4
 VIKING ZACK	6
 VIKING TEX	8

Verpackung

Packing

Emballage

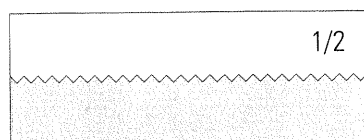
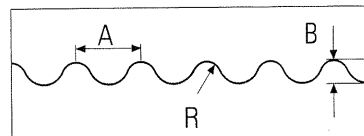
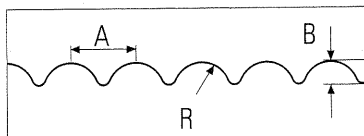
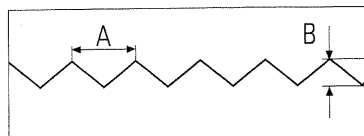
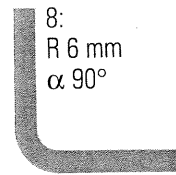
Embalaje 9



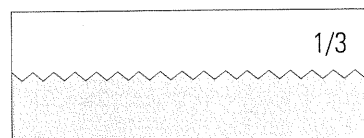
Zackenstahl
Gimpe steel
Acier dentelé
Acero prefestoneado

Maßstab/Scale/Echelle/Escala 1:1

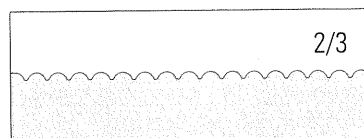
Biegefähigkeit
 Bendability
 Flexibilité
 Flexibilidad



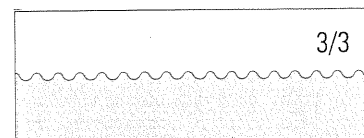
A 2 mm / B 1,0 mm



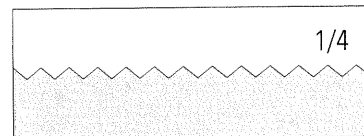
A 3 mm / B 1,2 mm



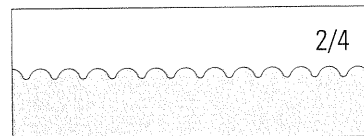
A 3 mm / B 1,0 mm / R = 1,3 mm



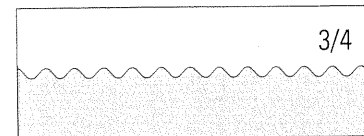
A 3 mm / B 1,0 mm / R = 0,7 mm



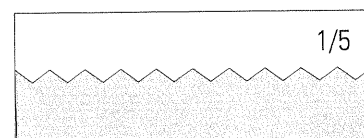
A 4 mm / B 1,6 mm



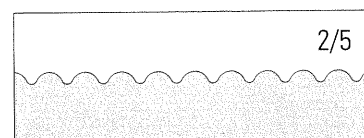
A 4 mm / B 1,4 mm / R = 1,6 mm



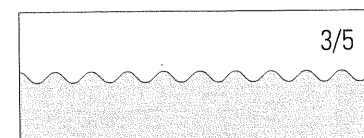
A 4 mm / B 1,4 mm / R = 0,8 mm



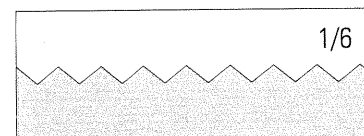
A 5 mm / B 1,8 mm



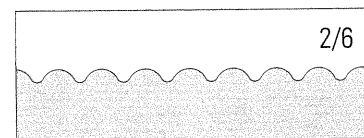
A 5 mm / B 1,6 mm / R = 2,0 mm



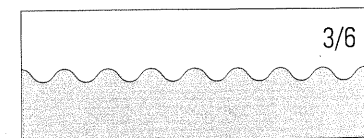
A 5 mm / B 1,5 mm / R = 1,2 mm



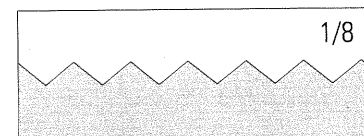
A 6 mm / B 2,4 mm



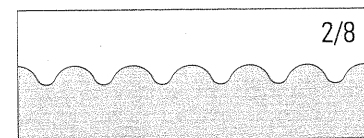
A 6 mm / B 1,8 mm / R = 2,5 mm



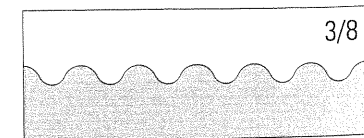
A 6 mm / B 1,8 mm / R = 1,6 mm



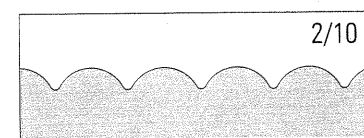
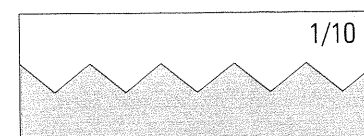
A 8 mm / B 3,2 mm



A 8 mm / B 2,6 mm / R = 3,0 mm



A 8 mm / B 2,6 mm / R = 2,5 mm



2/10

Abmessungen 19 x 2,0 20 x 2,0
30 x 2,0 32 x 2,0 mm

Einschneidig oder doppelschneidig,
Facette A

Lieferart: in Stäben à 1 m
Ringe 10–12 m

Bestellbeispiel:
19 x 2 D 1/3
Abm. 19 x 2 mm, doppelschneidig,
Zackenform 1, Zackenabstand 3 mm

Dimensions 19 x 2,0 20 x 2,0
30 x 2,0 32 x 2,0 mm

Single or double edged,
bevel A

Delivery: lengths 1 m, coils 10–12 m

Examples for ordering:
19 x 2 D 1/3
Dim. 19 x 2 mm, double edge, tooth
shape 1, distance of teeth 3 mm

Dimensions 19 x 2,0 20 x 2,0
30 x 2,0 32 x 2,0 mm

Simple ou double tranchant,
biseau central

Forme de livraison: barres d'un mètre,
rouleau de 10–12 m

Exemple de commande:
19 x 2 D 1/3
Dim. 19 x 2 mm, double tranchant, forme
des dents 1, distance de dent à dent
3 mm

Dimensiones 19 x 2,0 20 x 2,0
30 x 2,0 32 x 2,0 mm

de un filo o de dos filos
filo A central

Entrega: barras de 1 m, rollos 10–12 m


Ejemplo de pedido:
19 x 2 D 1/3
Dim. 19 x 2 mm, de dos filos, forma de
diente 1, distancia entre dientes 3 mm





VERKAUFSPROGRAMM

Gehärtetes und angelassenes Kaltband für Sägeblätter, Werkzeuge und Federn


 VIKING® Stanzmesserstähle für die Schuh-, Leder-, Textilindustrie u. ä.

 VIKING® Grafische Linien

Schaberklingen für die Papierindustrie und Druckereien

RANGE OF GOODS

Hardened and tempered cold rolled strip steel


 VIKING® clicking die steel for the shoe, leather, textile industries and similar


 VIKING® steel rule

Doctor blades for printing and paper industries

GAMME DE PRODUCTION

Feuillards d'acier laminés à froid pour outils et ressorts


 VIKING® Feuillard d'acier pour emporte-pièces pour l'industrie des chaussures, du cuir et du textile


 VIKING® Filets pour l'industrie de l'emballage et les arts graphiques

Racles à main

PROGRAMA DE VENTA

Fleje de acero en cinta laminado en frío para útiles y resortes

 VIKING® Fleje de acero para troqueles para la industria del cuero y del textil

 VIKING® Reglas artes gráficas

Cuchillas para la industria del papel e imprentas



CERTIFICATE

The TÜV CERT Certification body
of TÜV Austria
certifies in accordance with TÜV CERT procedures that

MARTIN MILLER AG

A-3133 Traismauer

has established and applies a quality system for

**Cold rolled strip steel, Clicking die steel,
Steel rule, Band saw blades for woodworking,
Steel centers for stone cutting.**

An audit was performed, Report No. 201004039 W7

Proof has been furnished that the requirements according to

EN ISO 9001

are fulfilled. The certificate is valid until **December 2000**
Certificate Registration No. **20 100 4039**



Erstzertifizierung: Jänner 1995



Wien, den 29. Dezember 1997

Handwritten signature
TUV CERT-Zertifizierungsstelle
des TÜV Österreich

AUSTRIAN SOCIETY FOR THE ADVANCEMENT OF PRODUCT QUALITY

Martin MILLER GmbH
A-3133 Traismauer

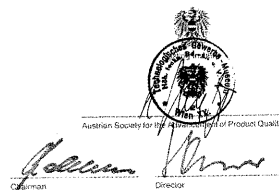
has been awarded

THE AUSTRIAN SEAL OF QUALITY

under Registration No. 10.378
in accordance with
Test Certificate No. WVB 4295, Dr. Kuntz1/K8
and with our regulatory standards,
till **July 31, 1999**

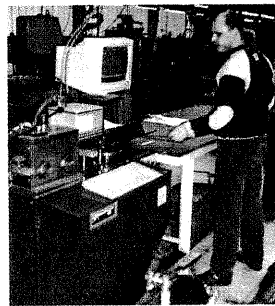
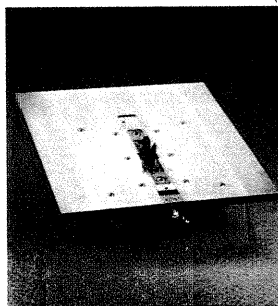
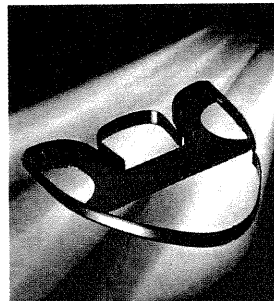
The aforementioned company is entitled to display
THE AUSTRIAN SEAL OF QUALITY
on its goods as listed below:

**SAW BLADES FOR WOODWORKING
STEEL CENTERS FOR STONE CUTTING
CLICKING DIE STEEL, STEEL RULE
BAND SAW BLADES, COLD-ROLLED STRIP STEEL**



Vienna, July 1997 / cu





MARTIN MILLER NORTH AMERICA
Parkside Industrial Business Center
3422C State Road
Cuyahoga Falls, Ohio 44223
PH: 800-241-6559 FAX: 330-929-4860

MARTIN MILLER GmbH, P.O. Box 62, Venusbergerstraße 22, A-3133 TRAISMAUER - AUSTRIA

ÄNDERUNGEN VORBEHALTEN
 RESERVE THE RIGHT OF CHANGING WITHOUT NOTICE
 MARTIN MILLER SE RÉSERVE LE DROIT DE CHANGEMENTS TECHNIQUES.
 MARTIN MILLER SE RESERVA EL DERECHO DE CAMBIOS TÉCNICOS.
 Copyright 01-1999 MARTIN MILLER GmbH